

EXHIBIT “A”

116E1707I1
SEQ - 5000 WORK INSTRUCTIONS
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FINAL FORM I-7804.94 DIE, FINAL FORM, P.B.

1ST/LAST PIECE ON FLOOR INSPECTION REQUIRED ON THE FOLLOWING CHARACTERISTICS:

- A) CONTOUR - COMPARE TO SAMPLE - 1ST/LAST PIECE MINIMUM
- z) MISC. DEFECTS - VISUAL - EVERY PIECE

PRESS BRAKE

MATERIAL: - SS

MACHINE NUMBER: - 820

SAMPLE REQUIRED? - YES

DEPTH POSITION (REF.)

DEPTH ADJ. (REF.)

TOP POSITION (REF.)

SPEED CHANGE (REF.)

TONNAGE (REF.)

RECORDED BY: - L. LEHMANN

DATE: - 03/30/01

APPROVED BY: - D. HIGBY

DATE: - 04/01/01

NOTES AND SET UP:

Clamp top half of die to ram, then align bottom half and clamp. Put part in die with big end between locator, and small end over pin. Make sure to close gate or part will be crushed. Setting is 0546 (ref).

REVISIONS:

- 10/20/00 - Revised notes; "hand form ... thru ... to hold part in location", also card was copied with machine change to #820 per D.L. - K.M.
- 03/05/01 - Cleaned up setup sheet to make easier to read. - D.A.J.
- 05/09/01 - Added rewritten setup sheet no changes just darkened up, also added operator acceptance criteria to work instructions. D.A.J.
- 02/19/02 - Converted the setup sheet to word format. - SPG
- 02/19/02 - Added picture per Stan Gallup. B.B.

